

Date: Thursday, 10/25/2007 10:14:07 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 35375	
Estimate Number : 12494	
P.O. Number :	Part Number : D35147
This Issue : 10/25/2007 S.O. No. :	Drawing Number : D3514 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34822	Material :
Written By : <u>[Signature]</u>	Due Date : 11/15/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 07-09-24 JLM verified by DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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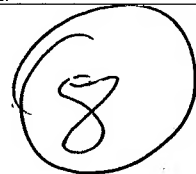


Comment: Qty.: 0.2518 sf(s)/Unit Total : 2.0143 sf(s)  
6061-T6 .040 Sheet  
(M6061T6S040)  
Batch: 165842 HB 07-10-31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3514  
Dwg Rev: A HB 07-10-31  
Prog Rev: A



\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary HB 07-10-31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-10-31

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6 7/10/31

counted  
(x8)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
Form Joggle as per Dwg D3514

HB 07/11/02

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 07/11/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>35375</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/02	3	1 piece slide under die bend out of Tolerance	<u>[Signature]</u>	Scrap & destroy	SB 07/11/02	<u>[Signature]</u> Muloz	<u>[Signature]</u>	<u>[Signature]</u> Muloz

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:14:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 35375

Part Number: D35147

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*6 of 102 (+F) counted*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 07-11-04 7*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*5 of 105 (+F) counted*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST-106*

*AS 07/11/06*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.11.07*

Job Completion



*07-11-07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

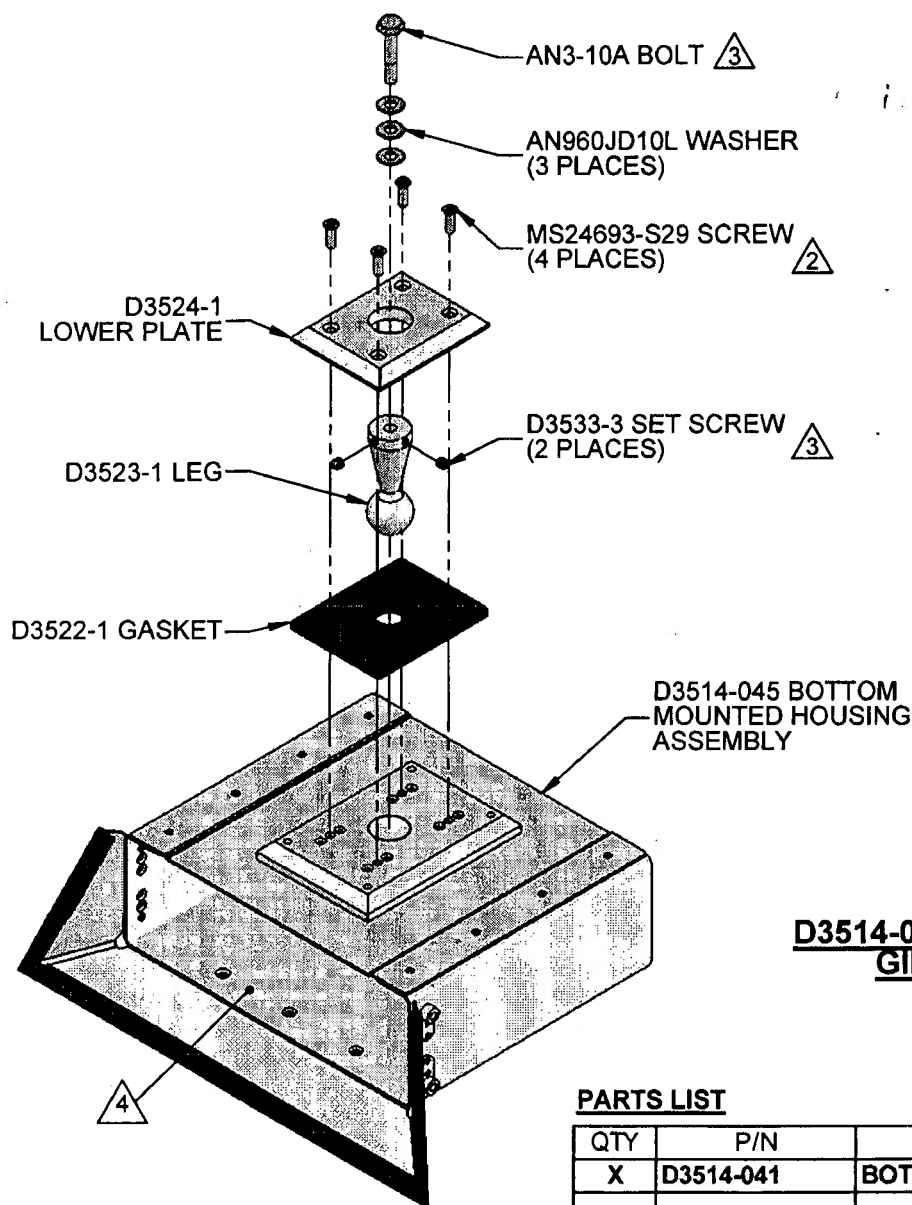
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	
REV A		DATE 07.06.18	DESCRIPTION NEW ISSUE
		SCALE 1:3	



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07.08.07

**D3514-041 BOTTOM MOUNTED  
GIMBAL ASSEMBLY**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35375

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

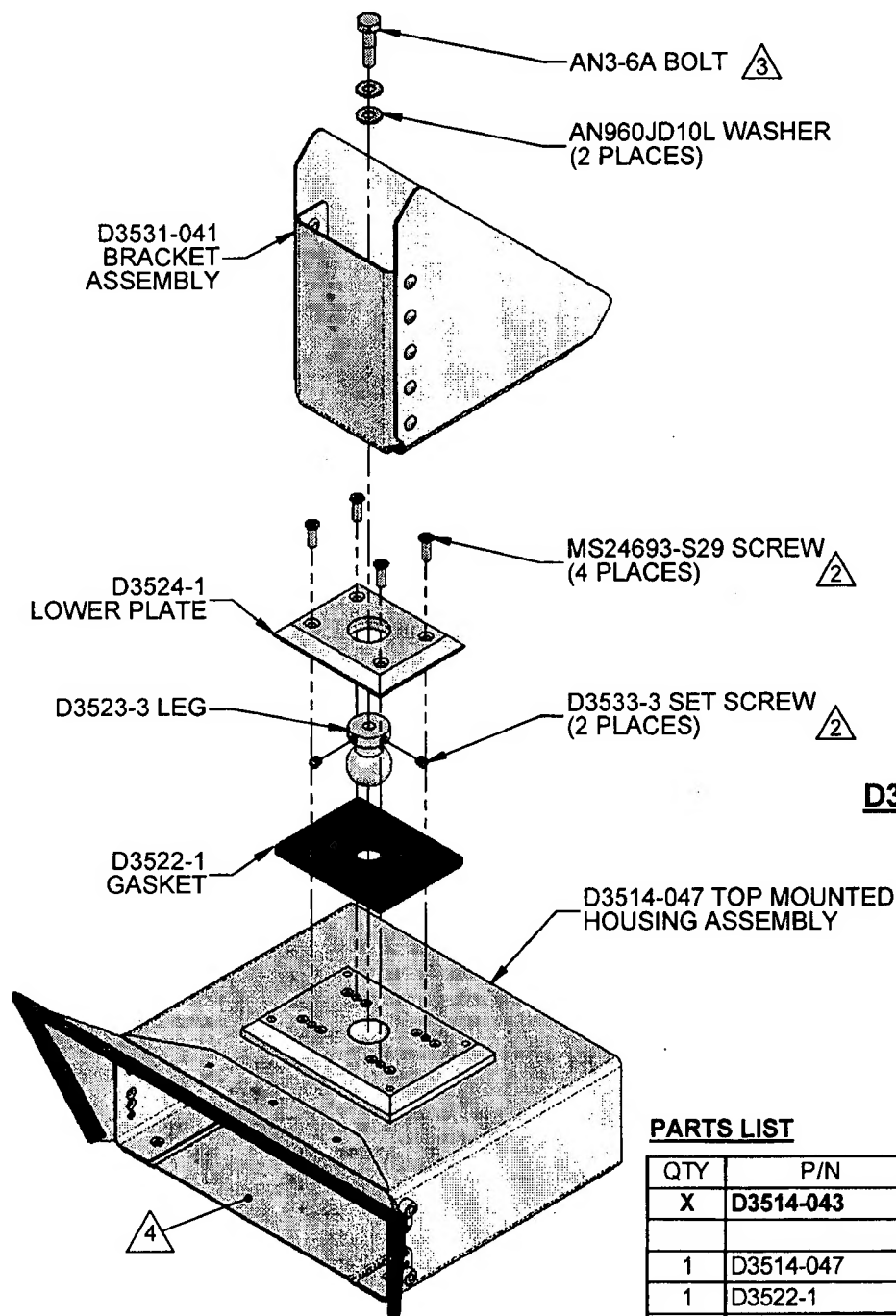
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 2 OF 9 SCALE 1:3

**RELEASED**  
07.08.03



**D3514-043 TOP MOUNTED  
GIMBAL ASSEMBLY**

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SUBJECT TO AMENDMENT

33315  
WORK ORDER

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

**PARTS LIST**

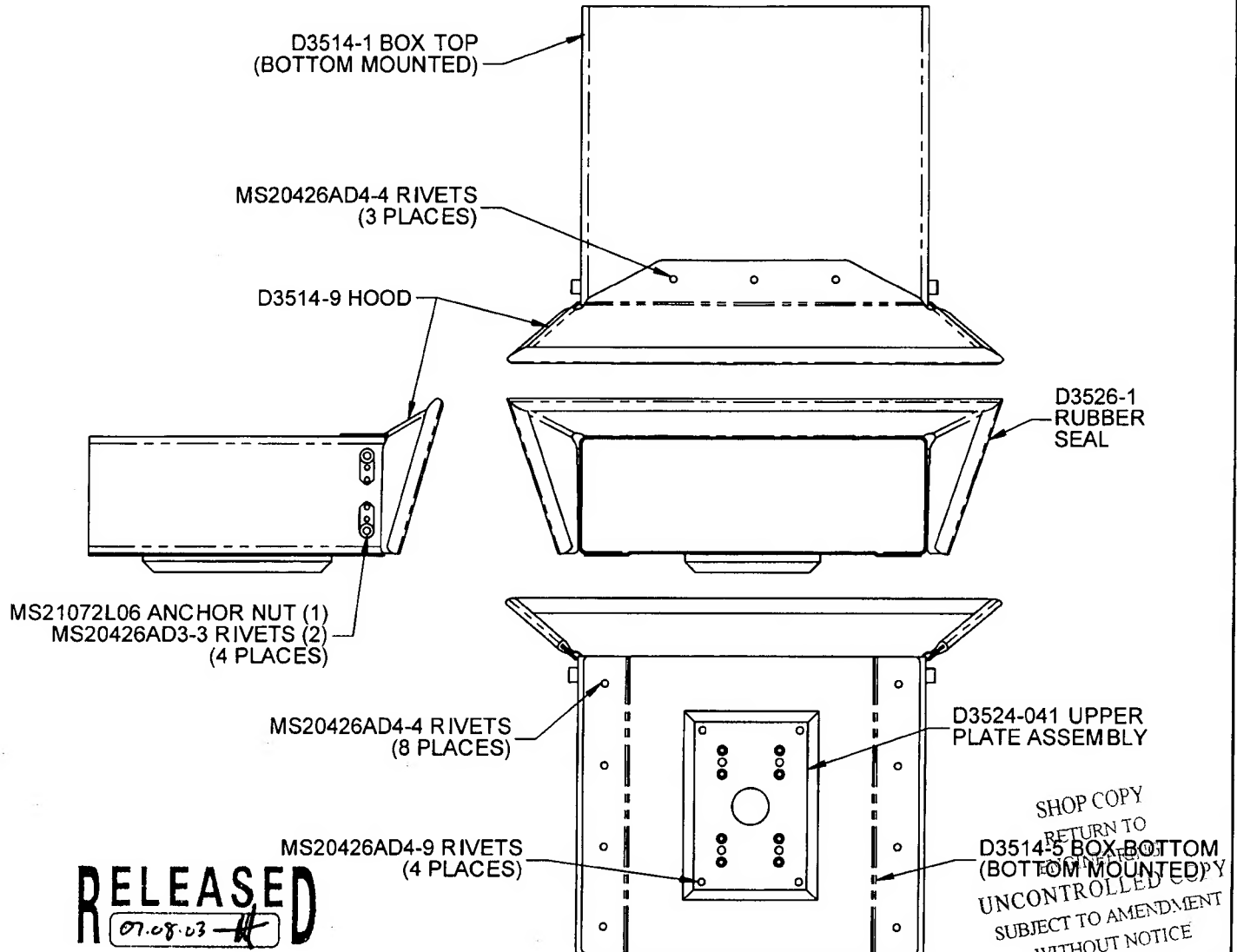
QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



### D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

#### NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

#### PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

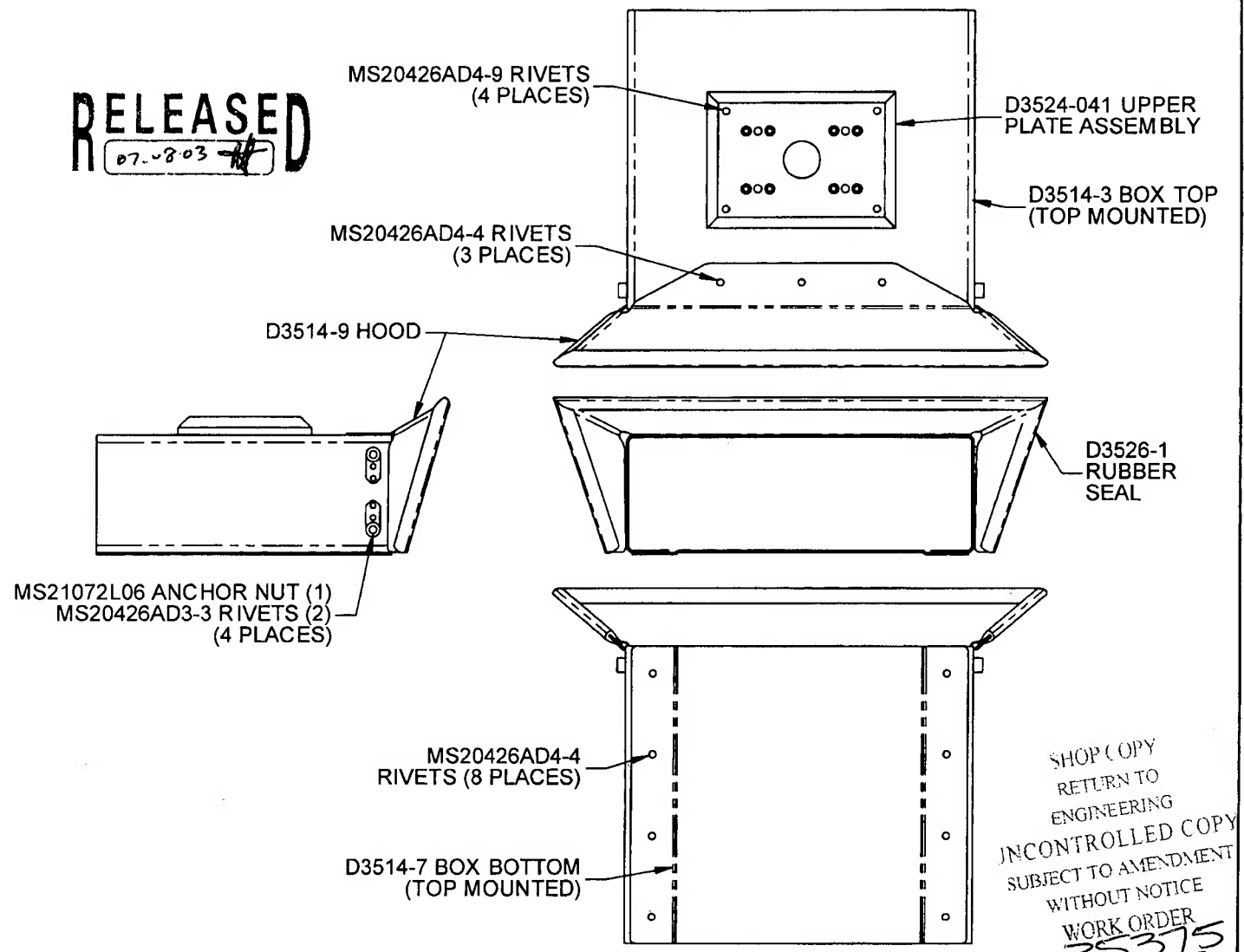
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**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

- NOTES:**  
1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.  
2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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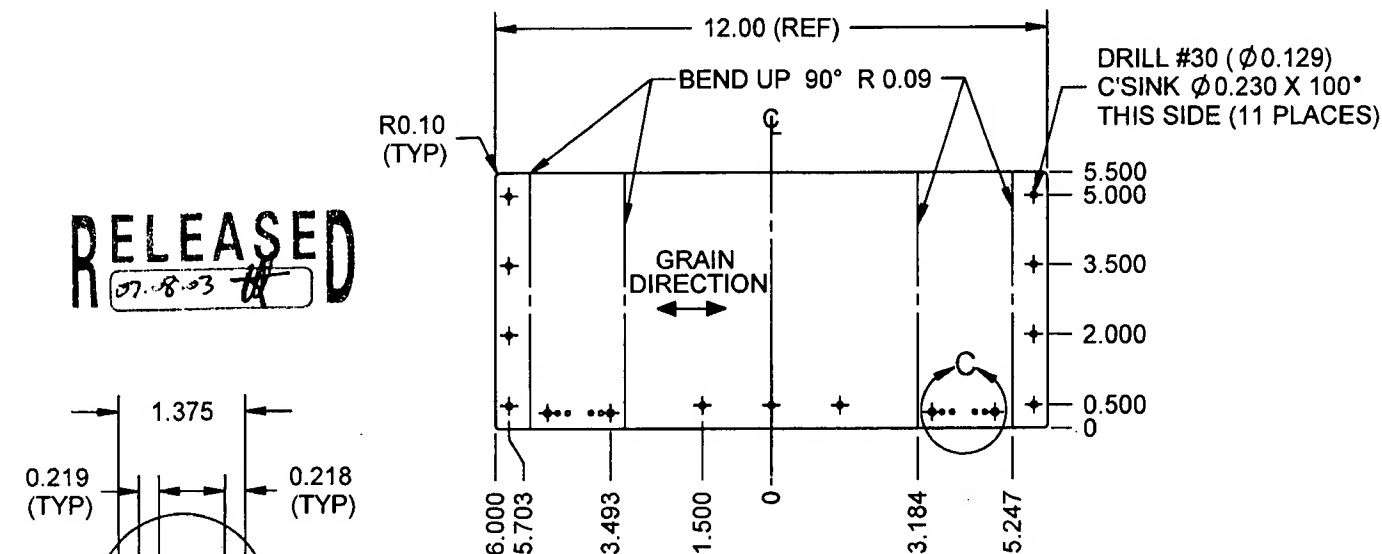
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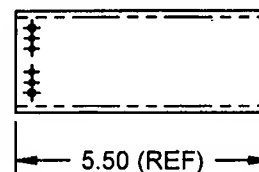
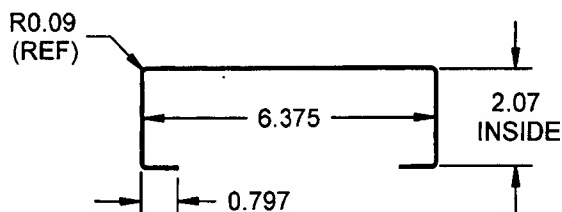
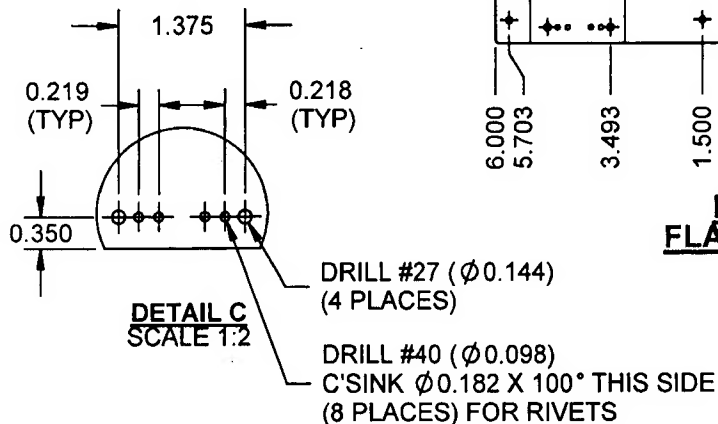
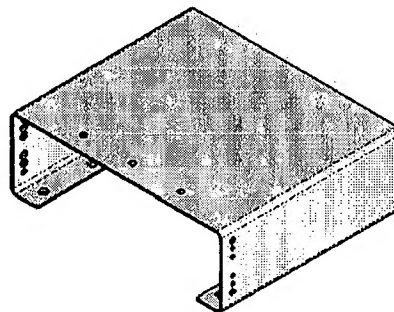


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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 5 OF 9 SCALE 1:4

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**D3514-1F  
FLAT PATTERN**



**D3514-1 BOX TOP (BOTTOM MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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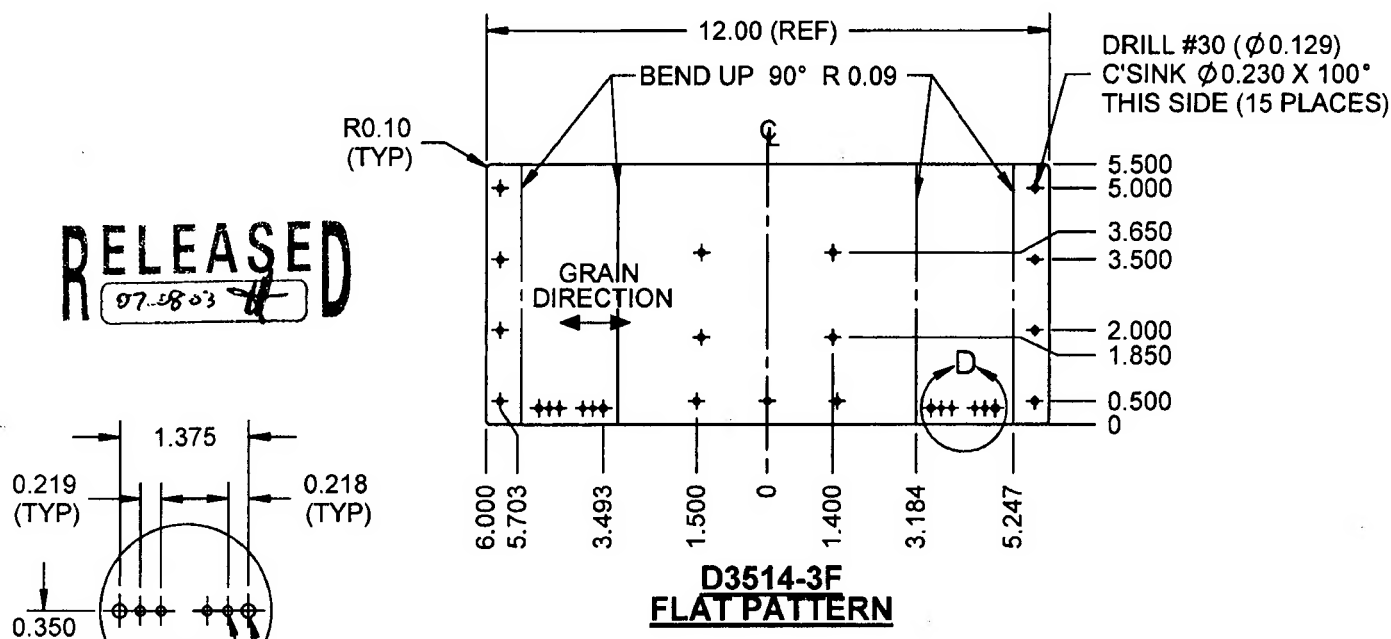
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 6 OF 9 SCALE 1:4

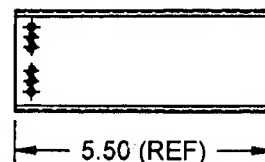
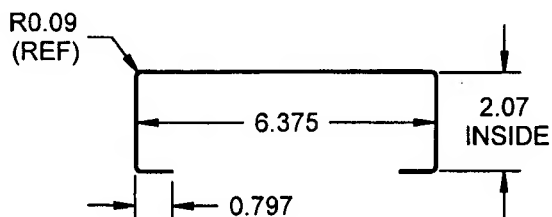
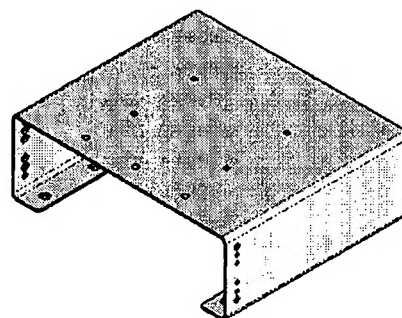
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**DETAIL D**  
SCALE 1:2

DRILL #27 ( $\phi 0.144$ )  
(4 PLACES)

DRILL #40 ( $\phi 0.098$ )  
C'SINK  $\phi 0.182 \times 100^\circ$  THIS SIDE  
(8 PLACES) FOR RIVETS



### **D3514-3 BOX TOP (TOP MOUNTED)**

#### **NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

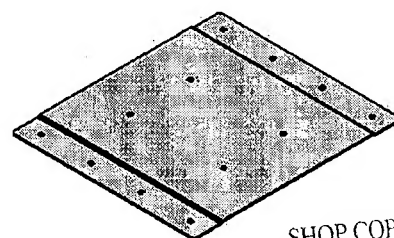
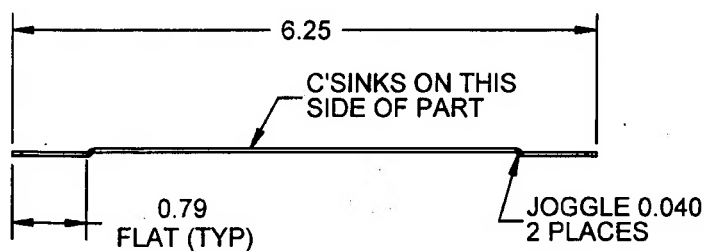
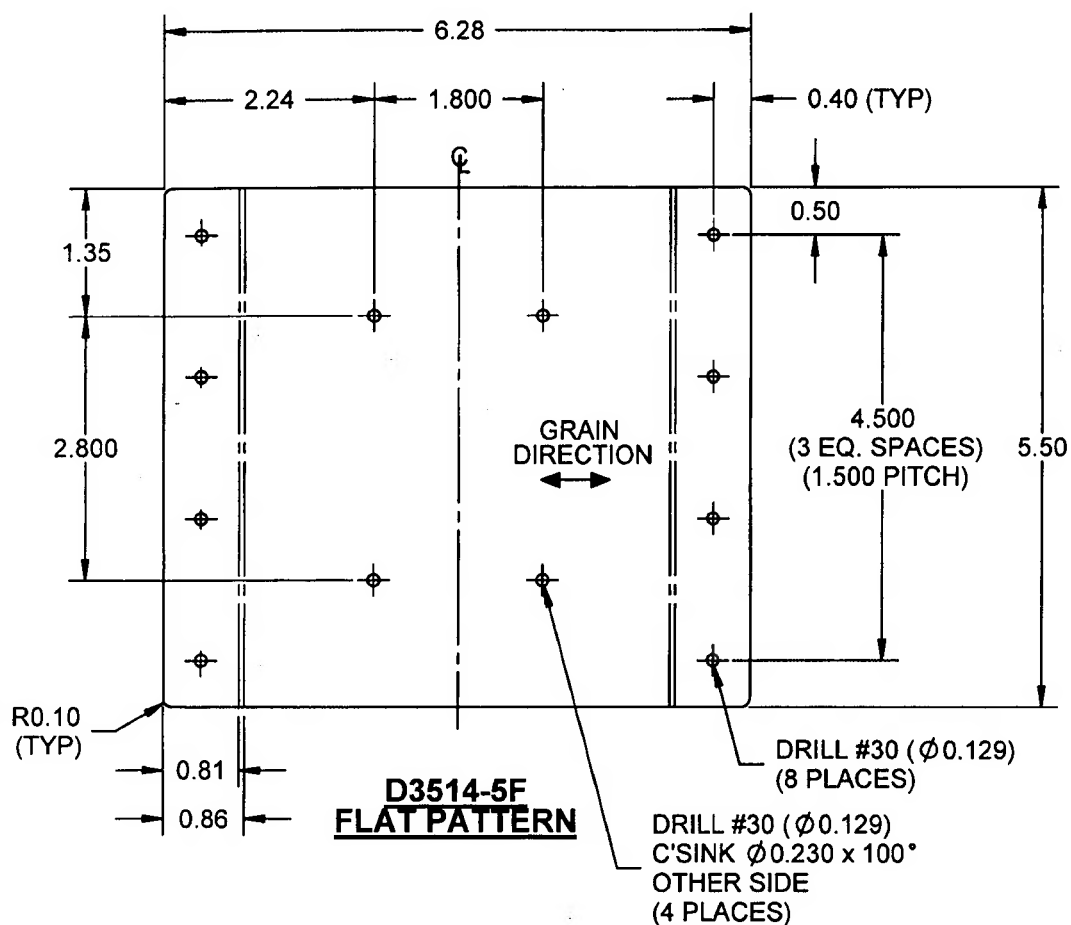
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 7 OF 9 SCALE 1:2



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WORK ORDER  
35375  
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#### NOTES:

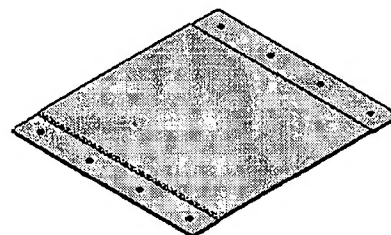
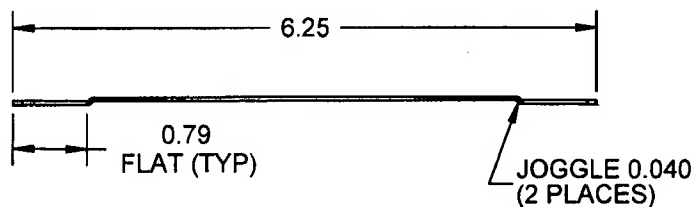
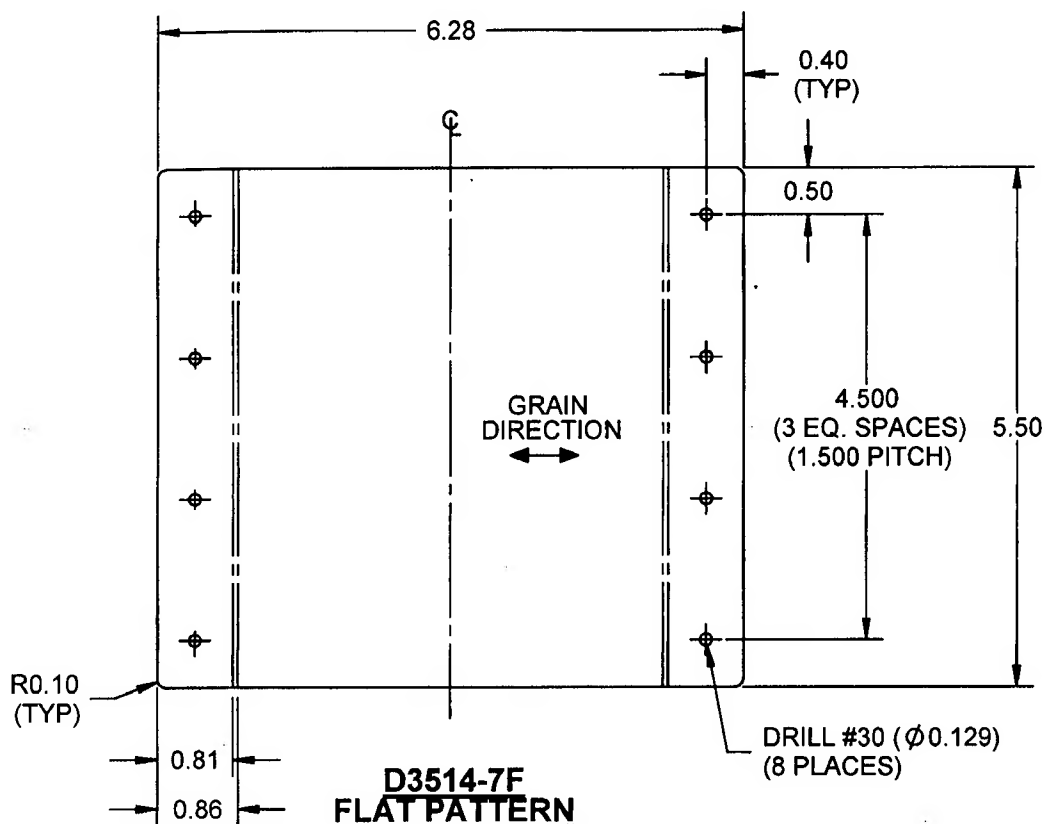
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINK ABOVE JOGGLE

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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 8 OF 9 SCALE 1:2



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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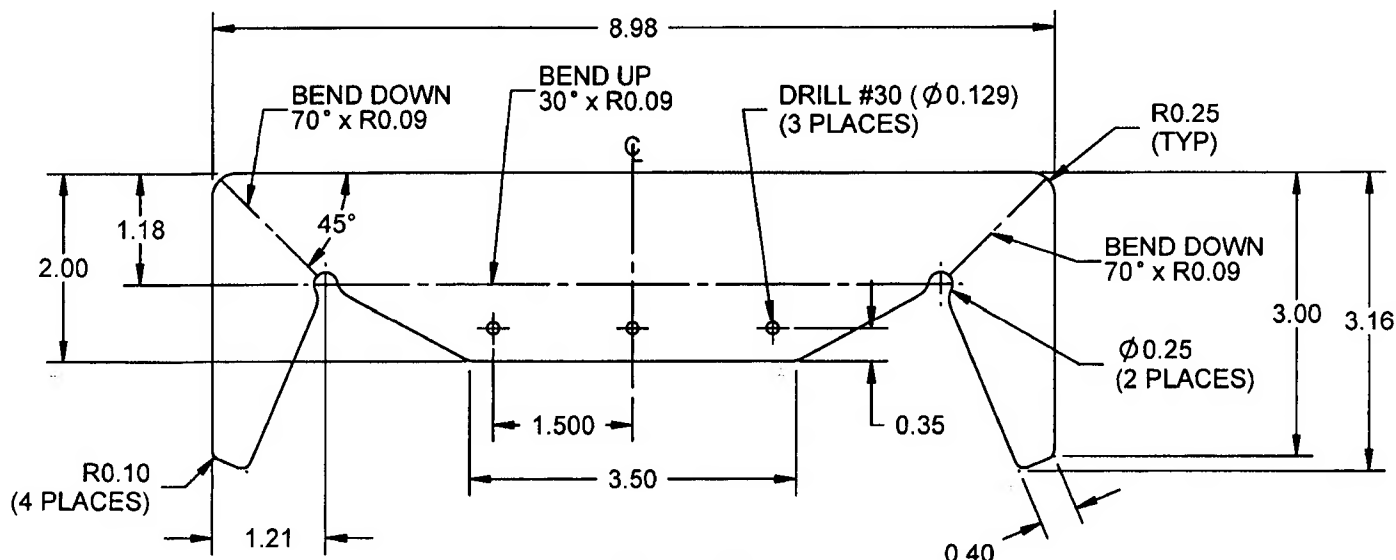
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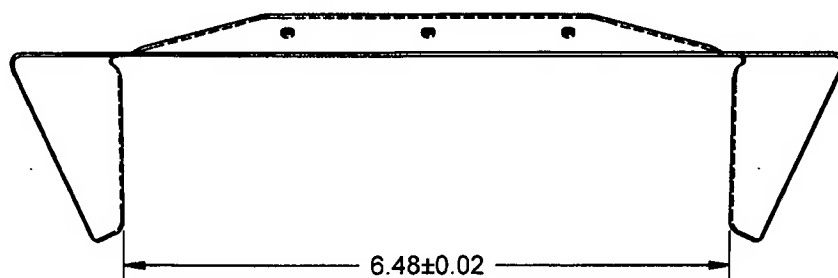
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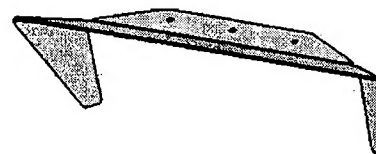
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DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 9 OF 9 SCALE 1:2



**D3514-9F**  
**FLAT PATTERN**



**FRONT VIEW**



**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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